

# Technical Data Sheet

## 3M™ Scotch-Weld™ Polyurethane Reactive (PUR) Easy 250 Wood Adhesive EZ250120

### Product Description

3M™ Scotch-Weld™ Polyurethane Reactive (PUR) Easy 250 Wood Adhesives are 100% solid, warm temperature applied, moisture curing urethanes. These products bond well to wood and wood based surfaces as well as select plastics. These products offer a wide variation of open and set times as well as the ability to produce very thin bond lines.

3M™ Scotch-Weld™ Polyurethane Reactive (PUR) Easy 250 Wood Adhesive EZ250120 is a medium setting, low viscosity adhesive ideal for bonding wood and producing thin glue lines.


### Product Features

- 100% solids
- Moisture curing urethane
- One component
- Rapid rate of strength build up
- Open time from 1.5 - 4 minutes
- Set times from 15 - 120 seconds


### Technical Information Note

The following technical information and data should be considered representative or typical only and should not be used for specification purposes.

### Typical Mixed Physical Properties

Property	Values	Additional Information
Open Time	4 min	View 

Notes: POR=Pop Off Rubber

Time to Handling Strength	120 s	View 
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Notes: Min time between bond creation and ability to support a 5 psi tensile load. Open and set times determined by RT environment. Higher temps will lengthen open and set times, while lower temperatures will shorten open time and set time.

### Typical Uncured Physical Properties

Property	Values	Additional Information
Color (solid)	White/Off-White	

Density (molten)	8.9 lb/gal	
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Viscosity	3000 cP	
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View 

Temp C: 121C  
Temp F: 250F


Notes: Measured on Brookfield viscometer with Thermosel using spindle #27

## Typical Cured Characteristics

Property	Values	Additional Information
Shore D Hardness	60	View 

Test Method: ASTM D2240

Temp C: 23C  
Temp F: 73F


Tensile Strength	4000 lb/in <sup>2</sup>	View 
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Test Method: ASTM D638

Test Name: At Break  
Dwell/Cure Time: 7.0  
Dwell Time Units: day  
Temp C: 23C  
Temp F: 72F

Notes: Die C, measured on .011" - .017" thick films

## Typical Performance Characteristics

Property	Values	Additional Information
Elongation at Break	625 %	View 

Test Method: ASTM D638

Dwell/Cure Time: 7.0  
Dwell Time Units: day  
Temp C: 23C  
Temp F: 72F

Notes: Die C, measured on .011" - .017" thick films

Application Temperature	121 °C
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Application Temperature	250 °F
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## Available Sizes

Available Package Sizes:

1/10th gallon cartridge<sup>1</sup> 2 Kilo bag<sup>3</sup> 5 gallon pail 55 gallon drum

10 fluid oz/295ml 2 Kgs(4.4 lb) 36 pounds (16.3 kg) 400 pounds (181.4 kg)

Thread size for nozzle M15 X 1.5 Slug OD. – 5.0in (127 mm) Pail ID. – 11.25in (285.8mm) Drum ID. – 23.6in (600.5 mm)

Pail Ht. – 13.5in (343 mm) Drum Ht. – 34.8in (883.9 mm)

<sup>1</sup>5 -1/10th gallon cartridges per case.

<sup>2</sup>10 disposable plastic nozzles are supplied with each case of adhesive.

<sup>3</sup>6 -2kg bags per case.

Approximate Coverage per container:

(Linear ft per container based on 1/8in dia. Bead size)

1/10th gallon cartridge 2 Kilo bag 5 gallon pail 55 gallon drum

250ft (76.2m) 1650ft (502.9m) 13,500ft (4114.8m) 170,200ft (51876.9m)

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## Storage and Shelf Life

For maximum shelf life, store product at 60°F (16°C) to 80°F (27°C), indoors and protected from exposure to moisture.

Products in 10 fluid ounce cartridges have a 12 month from date of manufacture while all others have a 6 month from date of manufacture shelf life in unopened containers.

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## Bottom Matter

3M

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## Trademarks

3M and Scotch-Weld are trademarks of 3M.

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## Automotive Disclaimer

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## Handling/Application Information

### Dispensing Equipment

3M™ Scotch-Weld™ Polyurethane Reactive (PUR) Easy 250 Wood Adhesive Cartridges can only be dispensed through the 3M™ Scotch-Weld™ Polyurethane Reactive Adhesive Applicator or the 3M™ Scotch-Weld™ Polyurethane Reactive (PUR) Easy 250 Adhesive Applicator. Other container sizes can be dispensed through bulk equipment specifically designed for use with hot melt polyurethane reactive adhesives (PUR). For more information on PUR application equipment, contact your

local 3M sales representative. All equipment must be used in strict accordance with the recommendations of the manufacturer.

Warning: Do not use Scotch-Weld polyurethane reactive (PUR) easy 250 wood adhesive above 275°F (135°C) and should not be applied to substrates that exceed 275°F (135°C).

Caution: Wear heat resistant gloves and safety glasses when handling.

### Directions for Use

Apply to clean, dry surfaces. Remove oil, grease and other contaminants by wiping with isopropyl alcohol.\* For fiber reinforced plastics and other materials that are often contaminated with mold release agents, it is recommended that the surface be solvent wiped, abraded and solvent wiped.\* For additional information, see section on surface preparation. After heating to recommended application temperature, apply adequate amount of 3M™ Scotch-Weld™ Polyurethane Reactive (PUR) Easy 250 Wood Adhesive to one of the substrates to be bonded. Join the substrates within the adhesives specified open time and hold/fixture the bonded part until the adhesive has adequately set. Do not use to bond metal or glass to itself or each other or cure will not occur due to low moisture vapor transmission of the substrate.

(Important: Adhesive heated at application temperature for more than 16 hours should be discarded.)

\*Note: When using solvents, extinguish all ignition sources, including pilot lights, and follow the manufacturer's precautions and directions for use.

Cleanup: Allow products to solidify. Remove uncured waxy material (usually within the first 20 minutes after application) by scraping with a putty knife or similar tool. For cured material, remove by cutting or sanding. Do not use heat or flame to remove adhesive.

Cure Time: The cure rate will vary depending on air temperature, relative humidity, substrate type and bond line thickness. Cure rate is more rapid on wood (moisture rich substrate) than on plastic.

#### Surface Preparation

All wood should be dry and free of contaminants such as sawdust, dirt or other substances that may interfere with the adhesive bonding process. If the surface to be bonded contains a coating or finish, bonds should be made and evaluated to ensure proper adhesion. It may be necessary to evaluate other 3M™ Scotch-Weld™ Polyurethane Reactive (PUR) Easy 250 Wood Adhesive products that are better suited to bond plastic surfaces.

## References

Property	Values
3m.com Product Page	<a href="https://www.3m.com/3M/en_US/p/d/b40069380/">https://www.3m.com/3M/en_US/p/d/b40069380/</a>
Safety Data Sheet SDS	<a href="https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=EZ250120">https://www.3m.com/3M/en_US/company-us/SDS-search/results/?gsaAction=msdsSRA&amp;msdsLocale=en_US&amp;co=ptn&amp;q=EZ250120</a>

## Family Group

Link Tags:

- EZ250015
- EZ250060
- EZ250120

Products	Open Time	Shore D Hardness
EZ250120	4 min	60
EZ250015	1.5 min	65
EZ250060	2 min	60

## ISO Statement

This Industrial Adhesives and Tapes Division product was manufactured under a 3M quality system registered to ISO 9001 standards.

## Precautionary Information

Refer to Product Label and Material Safety Data Sheet for health and safety information before using this product. For additional health and safety information, call 1-800-364-3577 or (651) 737-6501.

## Information

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